

Work Order ID 85593

June-12-12 8:14:04 AM

85593

Page 1

Item ID: D119-646-213

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12/06/12 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D119-646	B

100 0.00

100

DC 0.00

Document Control

Memo
Photocopy bluefile & type labels per PPP D119-646-213
CHG 001

JB 8/2/06/29

ML5 12/06/29

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

12/6/29

120 QC4- 100% Inspect kits for completeness 0.00

120

QC Memo 0.00

Quality Control

8/2/06/29

12/6/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85593

85593

Page 2

June-12-12 8:14:04 AM

Item ID: D119-646-213

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-642-213

Location:

PPP rev: **A**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/06/29

ME 12-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:14:08 AM

Page 1

Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-243 *D119-646-243* Replacement Float Skidtube w/ Training Wearplates		Manufactured	No			110	Each	0.0000	0	1			
D119-646-311 *D119-646-311* Ground Handling		Manufactured	No			110	Each	3.0000	1	1			
<div> <div>Location</div> <div>FG</div> <div>74798</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3883-1 *D3883-1* Saddle, Outboard LH		Manufactured	No			110	Each	3.0000	2	2			
<div> <div>Location</div> <div>ST429</div> <div>53048</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3884-1 *D3884-1* Saddle, Inboard LH		Manufactured	No			110	Each	3.0000	2	2			
<div> <div>Location</div> <div>ST429</div> <div>74821</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B85539\$

JB

74798

JB

53048

JB

12/06/20

74821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2652
Bushing

Manufactured No

110 Each

499.0000 16 16

**

JB

SP

Location

Loc Qty

Loc Code

FG	44
31985	44
ST013	455
73836	36
81951	61
83744	358

Purchased No

110 Each

78.0000 8 8

**

JB

SP

AN3C50A
Bolt

Location

Loc Qty

Loc Code

ST355	78
112761	20
114442	33
120447	25

Purchased No

110 Each

547.0000 18 18

**

121657 JB 12/06/20

SP

AN4C6A
Bolt

Location

Loc Qty

Loc Code

FG	4
103344	4
ST356	543
116704	2
120423	16
121656	25
21658	500

June-12-12 8:14:09 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 85593

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Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21250-05-006

Purchased

No

110

Each

36.0000

8
**

8

JB

MS21250-05-006

BOLT

Location

Loc Qty

Loc Code

ST305

36

112657

26

120747

10

112657

AN960C101

NAS1149C0332

Purchased

No

110

Each

21.0000

17
**

17

122063 JB

*AN960C101 *

washer

Location

Loc Qty

Loc Code

ST

21

107534

21

AN960C416L

NAS1149C0432R

Purchased

No

110

Each

0.0000

30
**

30

121255 JB

*AN960C416I *

WASHER

AN960C516L

NAS1149C0532

Purchased

No

110

Each

0.0000

8
**

8

119736 JB

12/06/20

*AN960C516I *

WASHER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates. LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased No

110

Each

1,415,000

8

8

**

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1343

118077

2

118614

51

118686

30

119758

20

121255

270

121708

970

121255

MS21043-4

Purchased No

110

Each

1,200,000

13

13

**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1160

119546

131

121162

529

121652

500

121162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-12-12 8:14:09 AM

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Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2712
Set Screw

Manufactured No

110 Each

785.0000

12

**

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

735

79585

35

81871

200

83559

250

84433

250

81871

D3672-7
Phenolic Washer

Manufactured No

110 Each

760.0000

24

**

Location

Loc Qty

Loc Code

ST060

760

73488

16

76279

244

81872

500

76279

D3672-3
Phenolic Washer

Manufactured No

110 Each

583.0000

30

**

Location

Loc Qty

Loc Code

ST060

583

84361

583

84361

D3407-041
Tow Ring

Manufactured No

110 Each

17.0000

1

**

Location

Loc Qty

Loc Code

ST463

17

82068

17

82068

June-12-12 8:14:09 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:14:09 AM

Page 6

Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3417-5

Manufactured No

110 Each

143.0000

9

1

**

D3417-5

Washer

Location

Loc Qty

Loc Code

ST042

143

78842

12

83318

50

84943

40

85466

41

83318

D3456-1

Manufactured No

110 Each

230.0000

0

1

**

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

223

80252

1

81876

22

83584

100

85223

100

83584

D3417-7

Manufactured No

110 Each

38.0000

0

1

**

D3417-7

Washer

Location

Loc Qty

Loc Code

ST042

38

51645

18

75054

20

75054

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:14:09 AM

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Work Order ID: 85593

85593

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Float Skidtube w/ Training Wearplates, LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960.ID416

NAS1149D0463J Purchased

No

110

Each

30.0000

6

6

2

AN960.ID416

Washer

**

121912 JB

12/06/20

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D119-646

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4.3 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
					1					X			D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
24									1				D3846-1	GASKET
25									1				D3846-11	GASKET
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-047	FWD TRAINING WEARPLATE ASSY
45											1		D3849-045	AFT TRAINING WEARPLATE ASSY
46											1		D3846-1	GASKET
47											1		D3846-11	GASKET
48											1		D3847-1	WEARPAD
49											1		D3847-11	WEARPAD
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
54											10		AN3C5A	BOLT
55											10		AN960C10L	WASHER (OR NAS1149C0332R)
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)

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Revision: B
Date: 09.06.29

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D119-646

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Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
100	3	3	3	3									AN3C45A	BOLT
101					(3)	(3)							AN3C50A	BOLT
102	3	3	3	3									AN3C45A	BOLT
103					(3)	(3)							AN3C46A	BOLT
104					(9)	(9)							D3904-1	WASHER
105	6	6	6	6	6	6							AN4C8A	BOLT
106	6	6	6	6	6	6							D3672-3	WASHER
107	6	6	6	6	6	6							AN960C416L	WASHER (OR NAS1149C0432R)
108	6	6	6	6	6	6							AN960JD416	WASHER (OR NAS1149C0463J)
109	12	12	12	12	(3)	(3)							AN960C10L	WASHER (OR NAS1149C0332R)
110	6	6	6	6	(6)	(6)							MS21043-3	NUT

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NOT NEED TO BE INCLUDED WITH KIT.
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.

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Revision: **B**
Date: 09.06.29